

Date: Wednesday, 3/14/2007 12:25:34 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE
 Job Number : 31193
 Estimate Number : 10831
 P.O. Number : N/A Part Number : D29321
 This Issue : 3/14/2007 S.O. No. : N/A Drawing Number : D2932 UNDER REVIEW C
 Prsht Rev. : NC Project Number : N/A CB
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B C 07.03.14
 Previous Run : 30484 Material : N/A 16
 Due Date : 3/30/2007 Qty: 8 Um: Each
 Written By :
 Checked & Approved By : 07.03.14
 Comment : Est: B 00.06.26 New DWG rev, (mpp 2069) EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 2X6.25X7.875

Issue material from stock:

7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length

Batch No: 325349

En 07/03/15

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number. En 07/03/15

1-Inspect part number and batch number are programmed correctly. SN 07.03.16

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

5-Deburr & TUMBLE

En 07/03/16

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

En 07/03/16

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

En 07/03/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/03/22

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 12:25:34 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 31193

Part Number: D29321

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.03.20

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

LL / M-P 07-03-20 (16)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q.M 07/03/21 (16)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/3/21 (16)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/3/21 (16)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/22

Job Completion



u 07.03.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 20 Date: 9/13/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31193
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. (B) and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.174	0.118	0.119	0.117		
B	0.100	0.140		0.170	0.119	0.119	0.119		
C	0.100	0.140		0.119	0.117	0.118	0.120		
D	0.210	0.230		0.222	0.219	0.219	0.220		
E	1.245	1.255		1.251	1.249	1.249	1.251		
F	1.245	1.255		1.248	1.249	1.249	1.251		
G	2.495	2.505		2.500	2.497	2.497	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.576	1.576	1.574	1.580		
J	2.495	2.505		2.496	2.498	2.497	2.500		
K	0.257	0.262	DT8683	0.259	0.259	0.257	0.259		
L	0.312	0.317	DT8686	0.312	0.314	0.314	0.315		
M	0.235	0.240		0.210	0.239	0.240	0.240		
N	0.100	0.140		not on Dwg.					
O	0.540	0.560		0.544	0.550	0.546	0.544		
P	0.490	0.510		0.497	0.502	0.504	0.502		
Q	3.715	3.725		3.721	3.719	3.718	3.719		
R	2.470	2.510		2.493	2.500	2.492	2.495		
S	0.240	0.270		0.257	0.255	0.253	0.249		
T	0.100	0.180		0.128	0.140	0.140	0.140		
U	1.625	1.635		1.626	1.629	1.628	1.627		
V	1.362	1.372		1.364	1.366	1.368	1.368		
W	0.316	0.321	DT8690	0.320	0.320	0.320	0.320		
X	1.125	1.145		1.132	1.130	1.130	1.132		
Y	1.565	1.585		1.571	1.570	1.568	1.570		
Z	5.970	6.010		6.002	6.003	6.003	6.005		
AA	0.015	0.035 (2)		0.025	0.025	0.025	0.025		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	en
Date:	07/03/16

Audited by:	SN
Date:	07.03.20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	#

DART AEROSPACE LTD	Work Order:	31193
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. <i>BC</i>		Page 1 of 1

CB 07.03.14

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev (B) and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.115	0.122	0.123	0.123		
B	0.100	0.140		0.121	0.125	0.116	0.114		
C	0.100	0.140		0.114	0.117	0.117	0.116		
D	0.210	0.230		0.221	0.218	0.215	0.217		
E	1.245	1.255		1.247	1.247	1.245	1.245		
F	1.245	1.255		1.247	1.247	1.245	1.245		
G	2.495	2.505		2.498	2.498	2.497	2.497		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.574	1.575	1.576		
J	2.495	2.505		2.498	2.498	2.495	2.497		
K	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
L	0.312	0.317	DT8686	0.314	0.314	0.314	0.314		
M	0.235	0.240		0.240	0.240	0.240	0.240		
N	0.100	0.140							
O	0.540	0.560		0.544	0.544	0.546	0.545		
P	0.490	0.510		0.498	0.500	0.498	0.498		
Q	3.715	3.725		3.720	3.717	3.718	3.718		
R	2.470	2.510		2.496	2.496	2.496	2.496		
S	0.240	0.270		0.244	0.244	0.242	0.243		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.632	1.627	1.627	1.628		
V	1.362	1.372		1.366	1.366	1.368	1.367		
W	0.316	0.321	DT8690	0.320	0.320	0.320	0.320		
X	1.125	1.145		1.139	1.136	1.137	1.137		
Y	1.565	1.585		1.578	1.575	1.575	1.576		
Z	6.990	6.010		6.002	6.003	6.003	6.002		
AA	0.015	0.035 (P)		0.025	0.025	0.025	0.025		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>Er</i>
Date:	07/03/16

Audited by:	<i>SA</i>
Date:	07.03.20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	

DART AEROSPACE LTD		Work Order: 31193
Description: 206 Saddle, Outboard, Left side		Part Number: D2932-1
Inspection Dwg: D2932 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.115	0.115	0.120	0.114		
B	0.100	0.140		0.120	0.124	0.124	0.125		
C	0.100	0.140		0.115	0.113	0.114	0.115		
D	0.210	0.230		0.221	0.223	0.222	0.224		
E	1.245	1.255		1.242	1.248	1.247	1.246		
F	1.245	1.255		1.250	1.248	1.247	1.246		
G	2.495	2.505		2.501	2.499	2.497	2.498		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.576	1.574	1.576		
J	2.495	2.505		2.500	2.499	2.497	2.497		
K	0.257	0.262		0.259	0.259	0.259	0.259		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.240	0.240	0.240		
N	0.100	0.140							
O	0.540	0.560		0.551	0.546	0.542	0.546		
P	0.490	0.510		0.500	0.498	0.497	0.496		
Q	3.715	3.725		3.720	3.720	3.719	3.719		
R	2.470	2.510		2.496	2.494	2.491	2.493		
S	0.240	0.270		0.245	0.247	0.248	0.245		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.630	1.626	1.626	1.628		
V	1.362	1.372		1.366	1.364	1.363	1.367		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.135	1.135	1.142	1.142		
Y	1.565	1.585		1.575	1.573	1.570	1.568		
Z	5.996	6.010		6.001	6.002	6.002	6.002		
AA	0.025	0.035		0.025	0.025	0.025	0.025		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	1 CP
Date:	07/03/20

Audited by:	SA
Date:	07.03.20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	

DART AEROSPACE LTD	Work Order: 31183
Description: 206 Saddle, Outboard, Left side	Part Number: D2932-1
Inspection Dwg: D2932 Rev. B	Page 1 of 1

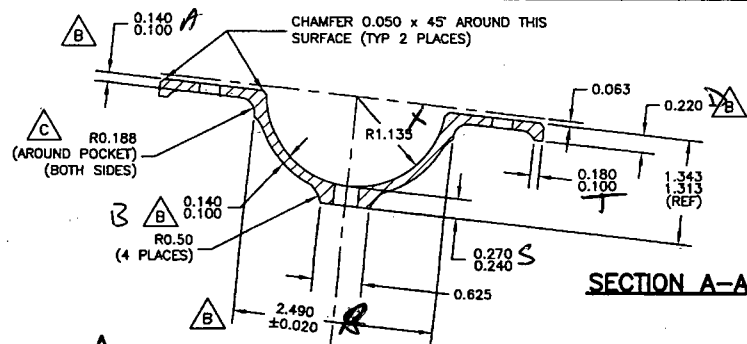
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. (B) and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
				13	14	15	16		
A	0.100	0.140		0.114	0.118	0.117	0.118		
B	0.100	0.140		0.124	0.123	0.122	0.124		
C	0.100	0.140		0.115	0.112	0.114	0.117		
D	0.210	0.230		0.220	0.219	0.221	0.223		
E	1.245	1.255		1.248	1.249	1.246	1.249		
F	1.245	1.255		1.248	1.249	1.246	1.249		
G	2.495	2.505		2.500	2.499	2.499	2.498		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.578	1.578	1.580	1.574		
J	2.495	2.505		2.498	2.495	2.497	2.498		
K	0.257	0.262		0.259	0.259	0.259	0.259		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.240	0.240	0.240	0.240		
N	0.100	0.140							
O	0.540	0.560		0.547	0.545	0.545	0.544		
P	0.490	0.510		0.492	0.493	0.495	0.498		
Q	3.715	3.725		3.720	3.718	3.721	3.718		
R	2.470	2.510		2.493	2.494	2.497	2.496		
S	0.240	0.270		0.247	0.248	0.247	0.249		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.628	1.626	1.629	1.631		
V	1.362	1.372		1.364	1.366	1.364	1.364		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.139	1.137	1.135	1.136		
Y	1.565	1.585		1.567	1.577	1.574	1.574		
Z	5.990	6.010		6.003	6.002	6.002	6.002		
AA	0.015	0.035		0.025	0.025	0.025	0.025		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

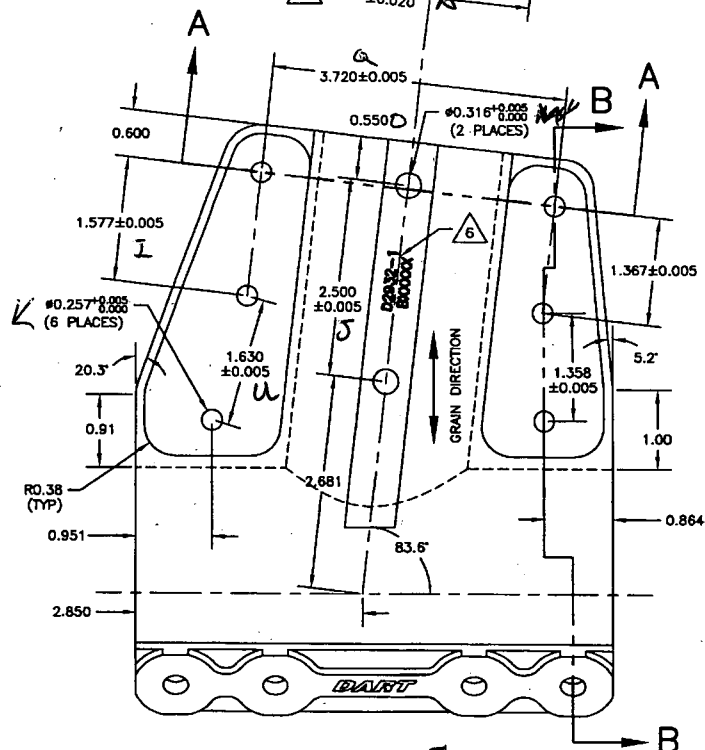
Measured by: En
Date: 07/03/20

Audited by: SA
Date: 07.03.20

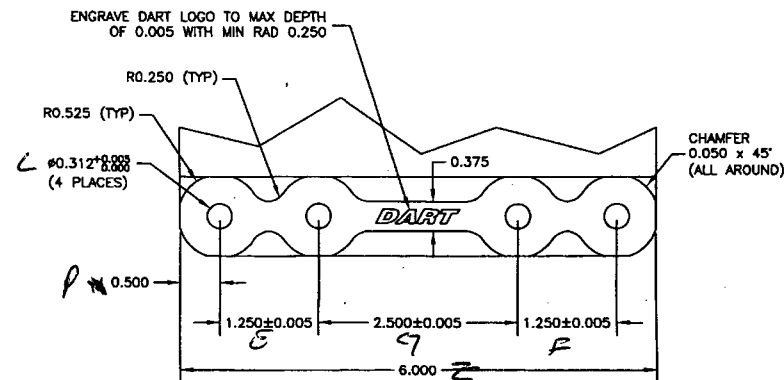
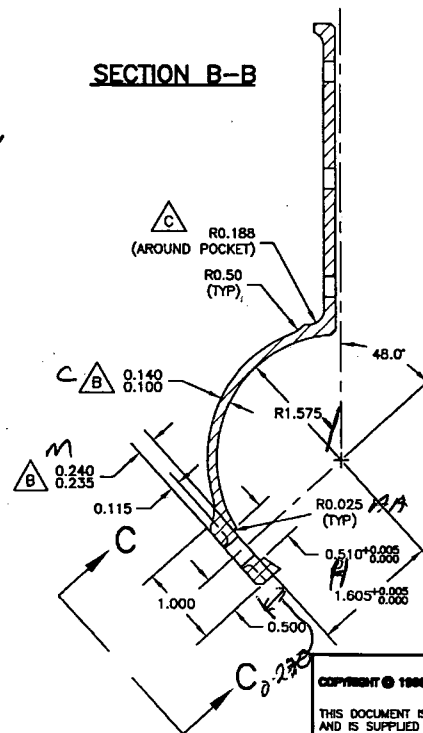
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	



SECTION A-A



SECTION B-B



VIEW C-C

D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP.

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. D2932
DATE		TITLE SADDLE OUTSIDE
06.11.09		REV. C SHEET 1 OF 1 SCALE 2:3

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RELEASED

07-02-2

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